


<b>Customer</b>	:	CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	:	STRUT
<b>Job Number</b>	:	25574				
<b>Estimate Number</b>	:	10961				
<b>P.O. Number</b>	:	N/A		<b>Part Number</b>	:	D2565209
<b>This Issue</b>	:	1/18/2006      S.O. No.	: N/A	<b>Drawing Number</b>	:	D2565 REV E
<b>Prsht Rev.</b>	:	NC		<b>Project Number</b>	:	N/A
<b>First Issue</b>	:	N/A                  Type	: SMALL /MED FAB	<b>Drawing Revision</b>	:	E
<b>Previous Run</b>	:	N/A		<b>Material</b>	:	N/A
<b>Written By</b>	:	SEE COMMENT BELOW				
<b>Checked &amp; Approved By</b>	:					
<b>Comment</b>	:	Est: D 01.06.04    Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21    EC				
				Qty:	10 Um:	Each

## Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
 		
Comment: Qty.: 1.3475 f(s)/Unit Total : 13.4747 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049) Batch No: <u>M18903</u> <u>FF 06-01-26</u>		
2.0	BRAKE NC	NC BRAKE
 		
Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313 <u>FF 06-01-26</u>		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
 		
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <u>DL 06/01/27</u>		
4.0	QC5	INSPECT WORK TO CURRENT STEP
 		
Comment: INSPECT WORK TO CURRENT STEP <u>06-01-31</u>		
5.0	POWDER COATING	POWDER COATING
 		
Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3 <u>06-03-14</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: DP Date: 06/02/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:11:10 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 25574

Part Number: D2565209

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*m/ 06 02 15*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*st 186*

*06/02/15*

*10*

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*545 06/02/16*

*(10)*

*(10) 06/02/16*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

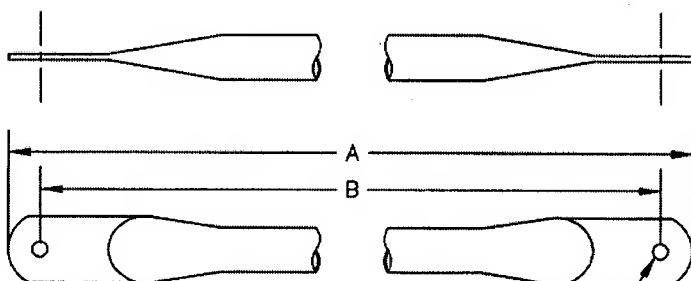
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

**RELEASED**  
04.05.05



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY  
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

**GENERAL NOTES**

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

WORK ORDER  
NO. 25574

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